

Work Order ID 84789

84789

Page 1

May-23-12 10:48:26 AM

Item ID: D206-642-441

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 5/23/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/24/12 Req'd Qty: 1.00

1

Customer:

Reference: rework to CHG003

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2650	Rev F								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

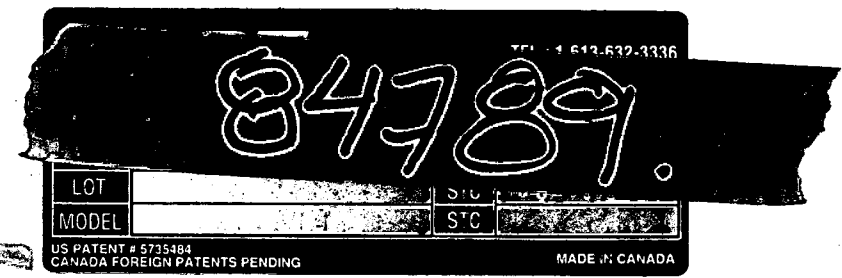
0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG003

11/12/06.04

ML5 12/06/04



84789

May-23-12 10:48:26 AM

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 5/23/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/24/12 Req'd Qty: 1.00 * 1 *

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

230

230

HandFinish

Hand Finishing

HandFinishing

0.00

0.00

Tool #

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

Memo

PULL FROM STK:

1 X D206-642-441 B31066

UPDATE TO CHG003 PER 09-531 DSI9440

REMOVE WEARPLATES:

6 X D2648-3 B29777

1 X D2656-15 B29335

1 X D2656-23 B29336

1 X D2656-37 B29338

1 X D3429-1 B30237

RETURN TO STK

DISCARD HARDWARE

ADD:

6 X D3537-1 B ~~81360~~ 81363.
1 X D3537-3 B ~~75537~~

1 X D3535-15 B 80328.

1 X D3536-15 B 86343

1 X D3535-23 B 83875.

1 X D3536-23 B 83377

1 X D353637 B 66823

1 X D3536-37 B 77668

60 X MS27039C1-08 B 10/162.

60 X AN960C10L (NAS1149C0332R)

B 121509.

Work Order ID 84789***84789***

Page 3

May-23-12 10:48:26 AM

Item ID: D206-642-441 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube
Start Date: 5/23/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/24/12 Req'd Qty: 1.00 ***1*** Customer:
Reference: rework to CHG003

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
250 *250* Packaging Packaging	Packaging Memo REPACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D206-642-441 Location: _____ PPP Rev: _____	0.00 0.00							
260 *260* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/24/6/1/ C

12/6/8 J

P1206-8

Picklist Print

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Page 1

Work Order ID: 84789

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 5/23/12

Required Date: 5/24/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H05.10.11Added D3429-1 per CHG002 KJ/CP/JLM
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K 10.09.27 SS washers
 for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-441 Replacement Skidtube		Manufactured	No				Each	0.0000		1			
D2648-3 Wearpad		Manufactured	No				Each	19.0000		-6		BL 12-5-23.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST 29477		-18				6			
				81513		1							
				ST237A		19							
				ST497A		18							
				82819		18							
D2656-15 Wearshoe		Manufactured	No				Each	6.0000		-1		BL 12-5-23.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP 29335		5				1			
				83601		5							
				Mezz		1							
				51455		1							
D2656-23 Wearshoe		Manufactured	No				Each	9.0000		-1		BL 12-5-23.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz 29336		9				1			
				43407		2							
				51468		7							

Picklist Print

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Page 2

Work Order ID: 84789

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 5/23/12

Required Date: 5/24/12

Start Qty: 1.00

Required Qty: 1.00

D2656-37 Manufactured No Each 21.0000

-1

BR 12-5-23.

Wearshoe

Location	Loc Qty	Loc Code
Mezz 29338.	21	
34510	2	
44550	7	
46497	1	
53019	11	

1

D3429-1 Manufactured No Each 16.0000

-1

BR 12-5-23

Wearpad

Location	Loc Qty	Loc Code
FP002 30237.	16	
40438	2	
43706	1	
44579	12	
65692	1	

1

D3535-15 Manufactured No Each 15.0000

1

BR 12-5-23.

Wearshoe

Location	Loc Qty	Loc Code
FP001	15	
80328 ✓	2	
81354	13	

1

D3535-23 Manufactured No Each 20.0000

1

BR 12-5-23.

Wearshoe

Location	Loc Qty	Loc Code
FP001	20	
81355	1	
83375 ✓	19	

1

D3535-37 Manufactured No Each 4.0000

1

BR 12-5-23.

Wearshoe

Location	Loc Qty	Loc Code
FP001 66	4	
71668 ✓	4	

1

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Shop Packet Print

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Picklist Print

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Work Order ID: 84789

Parent Item: D206-642-441

Start Date: 5/23/12

Required Date: 5/24/12

Parent Item Name: Replacement Skidtube

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No Each 18.0000
Gasket

1 BR 12-5-23.

Location	Loc Qty	Loc Code
FP002	18	
73318	14	
81343 ✓	4	

D3536-23 Manufactured No Each 14.0000
Gasket

1 BR 12-5-23.

Location	Loc Qty	Loc Code
FP002	14	
74510	1	
83377 ✓	13	

D3536-37 Manufactured No Each 19.0000
Gasket

1 BR 12-5-23.

Location	Loc Qty	Loc Code
FP002	19	
66823 ✓	7	
82623	12	

D3537-1 Manufactured No Each 91.0000
Wearpad

6 BR 12-5-23.

Location	Loc Qty	Loc Code
FG	10	
79833	10	
FP002	81	
69817	5	
81360 ✓	50	
81362	22	
83254	1	
83255	3	

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Shop Packet Print

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Picklist Print

May-23-12 10:48:26 AM

Page 4

Work Order ID: 84789

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 5/23/12

Required Date: 5/24/12

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No Each 26.0000

Wearpad

1 BR 12-5-23

Location	Loc Qty	Loc Code
FP002	26	
78836	4	
81363 ✓	22	

MS27039C1-08 Purchased No Each 1,142.0000

SCREW

60 BR 12-5-23

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308	354	
121068	108	
121162 ✓	660	
ST293	19	
116373	3	
118077	14	
119309	2	

60.

NAS1149C0332R ✓ Purchased No Each 3,196.0000

Washer

60 BR 12-5-23

Location	Loc Qty	Loc Code
ST297	219	
119736	196	
120648	23	
ST298	2977	
121255	11	
121509 ✓	2966	

60

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. L AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1

REF. CANADIAN STC: SH98-4

REF. FAA STC: SA00475SE

REF. EASA STC: EASA.IM.R.S.01320

84788 - 35469
84789 - 31066
84790 - 30440

INSTRUCTIONS:

1) FOR D206-642-111/-112/-211/-212/-213/-214 SKIDTUBES @ CHANGE 005 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2.
- ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2 AND PER FIGURE 1 ON SHEET 4.
- REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 2.
- AMEND THE PARTS LIST IN SECTIONS 4.1 AND 4.2 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.10 AND 32.11 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 2.

2) FOR D206-642-311/-312/-411/-412 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3.
- ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3 AND PER FIGURE 2 ON SHEET 4.
- REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 3.
- AMEND THE PARTS LIST IN SECTIONS 4.3 AND 4.4 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.12 AND 32.13 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 3.

B	P/N CORRECTION	AJS	09.03.25
A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 1 OF 4
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	WEARSHOE CHANGE	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

4.1 206 A/B Low Gear Skidtubes (D206-642)
32.10 206 A/B Low Gear Skidtubes (ICA-D206-642)

ITEM	Qty -111	Qty -112	Qty -141	Qty -147	PART NUMBER	DESCRIPTION
	X				D206-642-111	SKIDTUBE INSTALLATION, LH
		X			D206-642-112	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-141	SKIDTUBE
				X	D206-642-147	WEARSHOE KIT (REPLACES -143)
	1	1			D206-651-041	* 206 GHW ADAPTER ²⁰

IS:

20A			4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1	D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1	D3536-11	GASKET	(ADD)
23A			1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B			1	1	D3536-21	GASKET	(ADD)
24A			1	1	D3535-31	WEARSHOE (REPLACES D2656-31)	(MODIFY)
24B			1	1	D3536-31	GASKET	(ADD)
26A			42		MS27039-1C08	SCREW	(MODIFY)
26B			42		AN960C10L	WASHER	(MODIFY)

WAS:

20A			4		D2648-3	WEARPAD
21A			1		D3429-1	WEARPAD
22A			1	1	D2656-11	WEARSHOE
23A			1	1	D2656-21	WEARSHOE
24A			1	1	D2656-31	WEARSHOE
26A			42		MS27039-1-08	SCREW
26B			42		AN960JD10L	WASHER

4.2 206 A/B High Gear Skidtubes (D206-642)
32.11 206 A/B High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -211	Qty -212	Qty -213	Qty -214	Qty -241	Qty -247	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-247	WEARSHOE KIT (REPLACES -243)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ²⁰

IS:

20A					4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A					1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)	(MODIFY)
22B					1	1	D3536-13	GASKET	(ADD)
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B					1	1	D3536-21	GASKET	(ADD)
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)	(MODIFY)
24B					1	1	D3536-33	GASKET	(ADD)
26A					44		MS27039-1C08	SCREW	(MODIFY)
26B					44		AN960C10L	WASHER	(MODIFY)

WAS:

20A					4		D2648-3	WEARPAD
21A					1		D3429-1	WEARPAD
22A					1	1	D2656-13	WEARSHOE
23A					1	1	D2656-21	WEARSHOE
24A					1	1	D2656-33	WEARSHOE
26A					44		MS27039-1-08	SCREW
26B					44		AN960JD10L	WASHER

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE CHANGE	NTS
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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (D206-642)
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206 L/L-1/L-3/L-4 High Gear Skid tubes (D206-642)
32.13 206 L/L-1/L-3/L-4 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

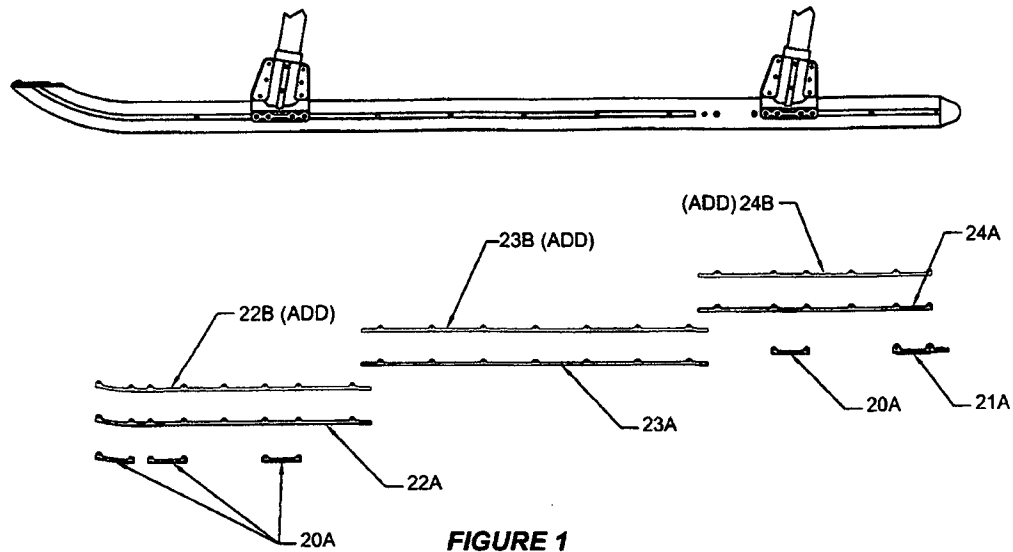
20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

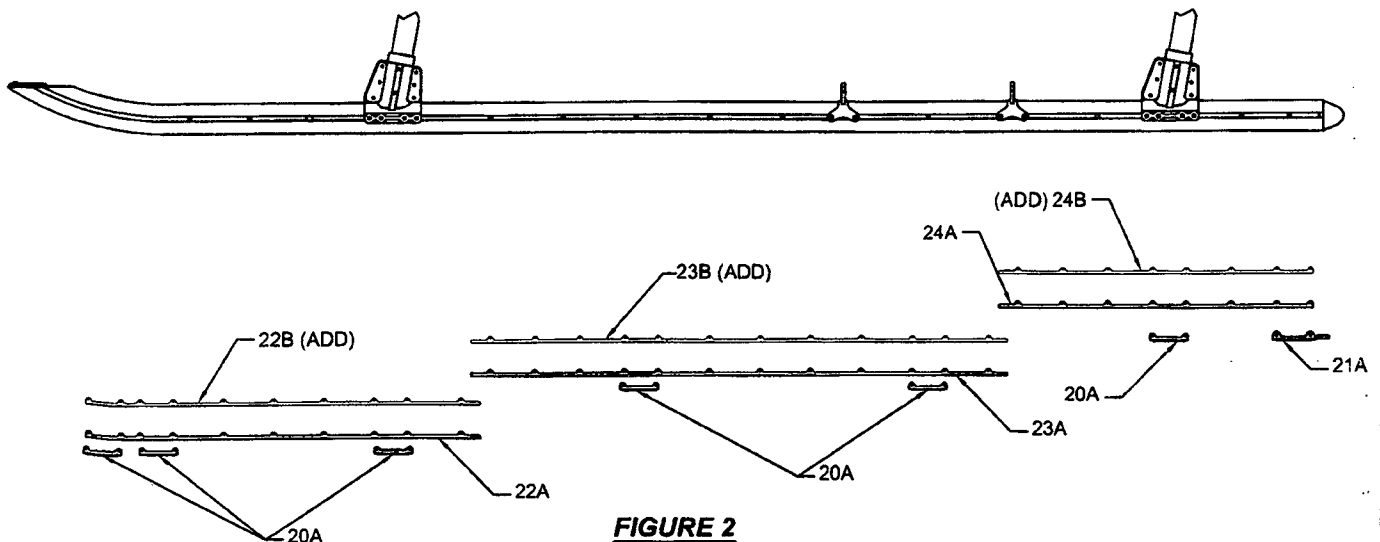
20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	HA	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	WEARSHOE CHANGE	NTS
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206 A/B SKIDTUBES
(D206-642-111/-112/-211/-212/-213/-214)



206 L/L-1/L-3/L-4/407 SKIDTUBES
(D206-642-311/-312/-411/-412)



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 4 OF 4
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	WEARSHOE CHANGE	NTS
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Part Number DZ06-642-441
Description 206 SKID TUBE

Chg.	Date	By	Relevant Documents
1	99.04.25	DS	MDL-D206-642 Rev. J
2	05.10.04	CP	Add D3475-1 (WEARPAD) MDL-D206-642 Rev 0
003	09.02.19	NY	DS19440 Rev A (ECN 09-531)

List Lots

May-23-12 9:24:04 AM

Page 1 of 1

Criteria : Item ID: d206-642-441 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D206-642-441 Replacement Skidtube	Main Warehouse FG080	30940	5/11/12	1.0000	QC21	CHG002	
	Main Warehouse FG080	31066	5/11/12	1.0000	QC21	CHG002	
	Main Warehouse FG080	35469	5/11/12	1.0000	QC21	CHG002	
Total:				3.0000			

Date: Wednesday, 10/31/2007 3:26:01 PM
 User: Kim Johnston

Process Sheet

48

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 35469
 Estimate Number : 10522
 P.O. Number : NIA Part Number : D206642441
 This Issue : 10/31/2007 S.O. No. : NIA Drawing Number : D2650 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LANDING GEAR Drawing Revision : E
 Previous Run : 34564A Material : NIA
 Written By : Due Date : 11/30/2007 Qty: 1 Um: Each
 Checked & Approved By : 10.11.01
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JL
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

①
 KB 07.11.01

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2620 Bent Tube 3" OD BE 34692 BE 7-11-05

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2647 Fwd Cap BE 29328 BE 07-11-05

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube BE 07-11-05

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 BE 07-11-05

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M 105138 BE 07-11-05

4-Grind weld flush to cap on top surface only. BE 07-11-05

Date: Wednesday, 10/31/2007 3:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35469

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 07-11-06

6.0 D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

34594

SL 7-11-6

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) BE 07-11-06

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) BE 07-11-06

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. BE 07-11-06

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 7-11-6 Time: 8:45

Finish Date: 7-11-6 Time: 7:30 am

AVR Sikaflex-291 105488

Sikaflex expiry date: 8-7-1

SL 7-11-6

Date: Wednesday, 10/31/2007 3:26:01 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35469

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/11/07

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

334508

BE 07/11/07

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M105238

BE 07/11/07

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

) M 7-11-8

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B 33061

① M 7-11-8

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

M103525

② M 7-11-8

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

Date: Wednesday, 10/31/2007 3:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35469

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 M7885/3-4-3

Rivets

M102515

②

M 7-11-8

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

M 7-11-8

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 07-11-09 (1)

16.0

QC5

INSPECT WORK TO CURRENT STEP.



Comment: INSPECT WORK TO CURRENT STEP

E 7/11/09

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-H 07/11/12

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M-H 07/11/12

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-11-13

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B33059

BR

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

D32579

BR

BR 07-11-13

Date: Wednesday, 10/31/2007 3:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35469

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B34171

BR

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B3450

BR.

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B34012

BR

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

M10572A

or (see QSI 017)

BR

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M104374

BR

BR 07-11-B

Date: Wednesday, 10/31/2007 3:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35469

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

m 105076

BR

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

B 33349

BR

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B 34592

BR

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

m 105426

BR

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

m 1594

BR

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

BR 07-11-13

Date: Wednesday, 10/31/2007 3:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35469

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D2646

Aft Cap

B 31335

BR

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

MA 104374

BR

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

MA 105076

BR

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

MA 105585
08-07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

MA 105585
08-07

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

MA 106030 BR 07-11-13

BR 07-11-13

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

84789

RELEASED
08.07.23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

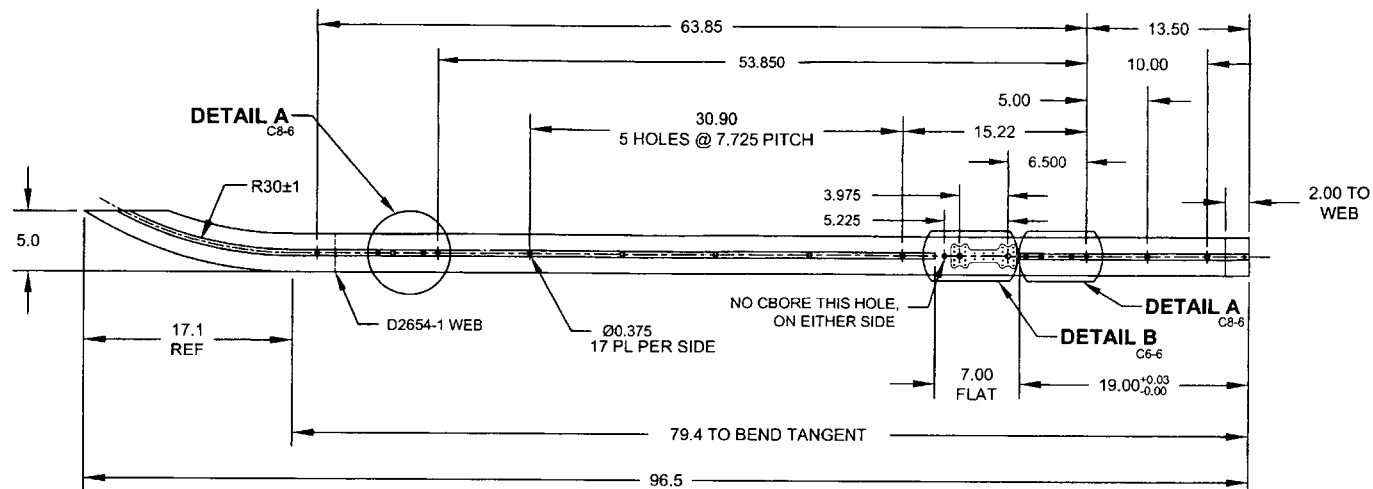
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

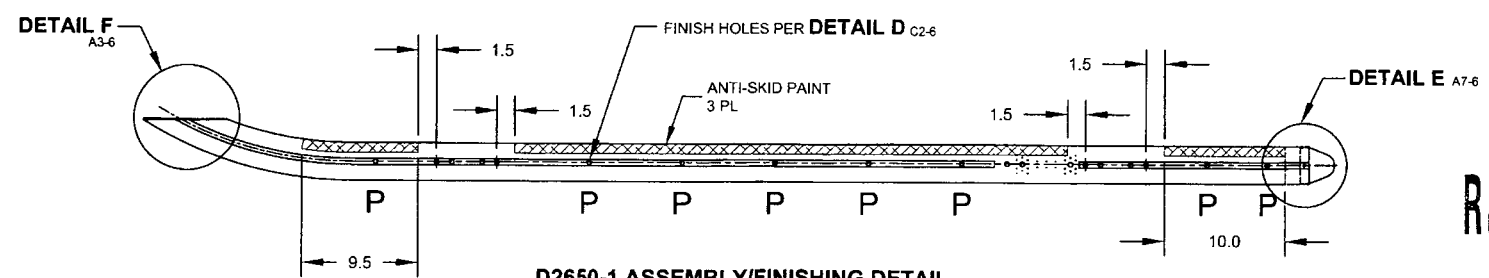
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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484789

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68-67 22/100

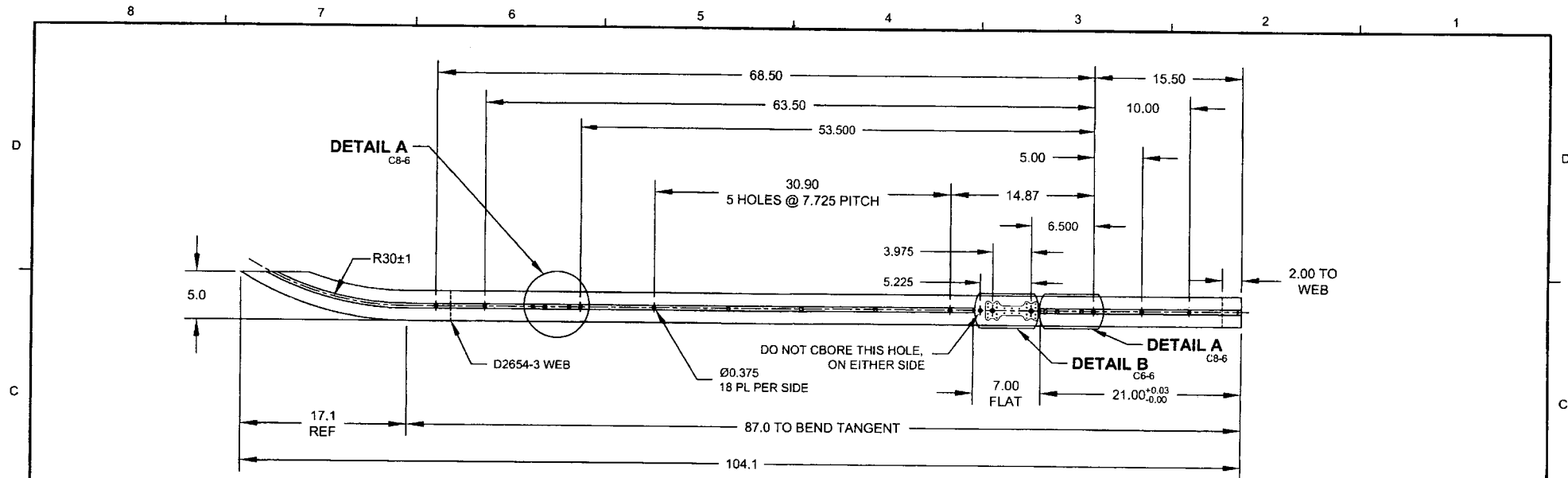
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

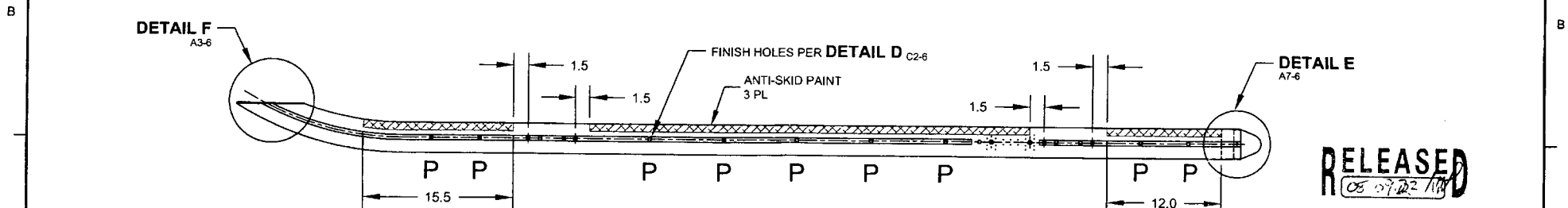
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
05 07 22 100

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 3 OF 6
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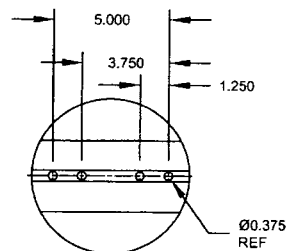
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

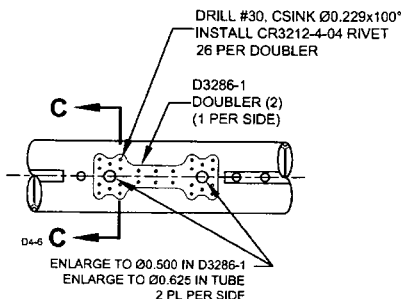
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

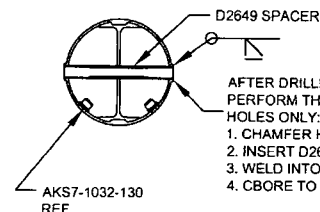
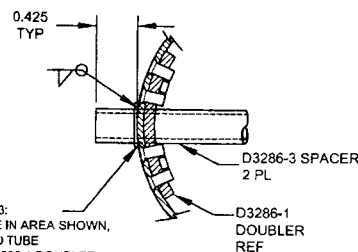


DETAIL B
SCALE 2X
C3-2
C3-3

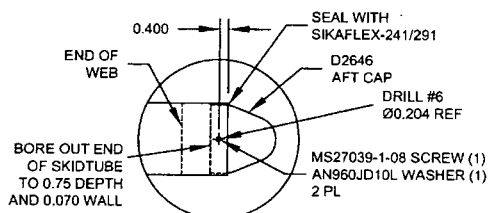
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



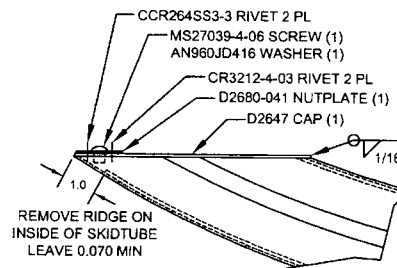
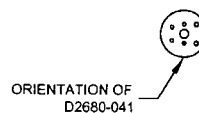
SECTION C-C C7-6
SCALE NONE



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5






DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 8
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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